

**Work Order ID 52857**

October 15, 2009 2:47:03 PM

Page 1

Item ID: D206-642-251

Revision ID: M

Item Name: Replacement Skidtube

Start Date: 15/10/2009 Start Qty: 1.00

Required Date: 27/10/2009 Req'd Qty: 1.00

Reference:

Approvals: Process Plan: BL Date: 09-10-15 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D3804	A
-------	---

IIN-D206-642	M
--------------	---

100

0.00



DOCUMENT CONTROL

DC

0.00

Document Control

Memo

Photocopy bluefile &amp; type labels per PPP D206-642-251

CHG001

N/A

LEFT

# Work Order ID 52857

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Item ID: D206-642-251

Accept



Setup Start



Revision ID: M

Stop



Item Name: Replacement Skidtube

Start Date: 15/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 27/10/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

110

0.00



Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1-Debur Fwd edge of tube

2- Remove ridge on inside of Fwd edge of tube as per Dwg D3804

3-Weld Fwd Cap as per Dwg D3804. Use aluminum rod. Grind D2647 to fit as required.

Pick:

Qty ☐ Part Number ☐ Description ☐ Batch  
A/R ☐ Aluminum Rod ☐

4-Grind weld flush to cap on top surface only.

5-Cut Aft end as per dwg D3804 from front of tube and Debur

6-Remove inner indexing ridge on Aft end of skidtube as per Dwg D3804

7-Open holes for Aft end cap as per Dwg D3804 with #30 Drill Bit using DT8025.

8-Drill pilot holes using Dt 8167.

9-Locate DT8732 from inner Aft saddle hole & 3rd crossbolt hole. Insert D3286-1 doubler using DT8732 & D206-642-241-T1, then locating doubler off of 3/16" holes, cleco DT8732 & doubler leaving DT8732 for added support.

10- Drill D3286-1 doubler rivet holes in tube using # 40 drill, spot drilling doubler at the same time.

9-10-19

7109213/7111999 BE 07-10-20  
BE 09-10-20

AWM 9-10-21

M 9/10/26

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Item ID: D206-642-251

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Setup Start



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Stop



Item Name: Replacement Skidtube

Start Date: 15/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 27/10/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

11-Working from the center out, drill # 30 holes into D3286-1 doubler. Cleco each hole as it is being drilled. Verify angle of holes to accommodate rivet heads.

12-Remove 3/16" cleco's only and open GHW holes to Ø0.500" as per Dwg D3804

13-Remove D3286-1 doublers, identify orientation, deburr, then attach them to the workorder

14-Remove indexing edge using DT8741 as per Dwg D3804

15-C'sink GHW rivet holes as per Dwg D3804

1 11/10/26

120



QC

Quality Control

QC6- Inspect dimensions to drawing

0.00

0.00

Memo

z> Sorkolze



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Item ID: D206-642-251

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Setup Start



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Stop



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Cust Item ID:

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Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

130

0.00



Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1-Open crossbolt holes to Ø0.3125"

2- Open Aft cap hole #6.

\*\*\*\*no wearplate holes for this skidtube\*\*\*\*

3-Deburr tube and blow out chips from inside the tube

①

BE 09/10/26

140

0.00



Chemical Conversion Coat per QSI005 4.1

HandFinish

Memo

0.00

Hand Finishing

1

u 9/10/27

150

0.00



QC3- Inspect Part Finish

QC

Memo

0.00

Quality Control

DD 9-10-27

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Item ID: D206-642-251

Accept

Setup Start

Revision ID: M

Stop

Item Name: Replacement Skidtube

Start Date: 15/10/2009 Start Qty: 1.00

Cust Item ID:

Required Date: 27/10/2009 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

160

0.00



Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1-Open holes to finished size as per Dwg D3804, (without cutting fluid)

2-C'sink crossbolt spacer holes as per Dwg D3804(without cutting fluid)

3-Deburr and blow out all chips from inside the tube

1 11 9/10/27

170

0.00



QC6- Inspect dimensions to drawing

QC

Memo

0.00

Quality Control

2) 8/10/07

② f

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Item ID: D206-642-251

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Stop



Item Name: Replacement Skidtube

Start Date: 15/10/2009 Start Qty: 1.00



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Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

180

0.00



Skidtubes

Skidtubes

Memo

0.00

1-Locate, install and rivet doublers as per Dwg D3804. Micro-shave rivets as required

2-Bond D2654-3 web in place as per QSI 015. Ensure holes line up. Allow 12 Hrs. cure time before cutting

Start Date: ☒ 9-10-27 ☐ Time: ☒ 4pm ☐

Finish Date: ☒ 9/10/26 ☐ Time: ☒ 10:00AM ☐

Pick:

Qty ☐ Part Number ☐ Description ☐ Batch

A/R ☐ Sikaflex-291 ☒ M112391 ☐

Sikaflex expire date: ☒ 2010/2/20 ☐

190

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

27/8 09/10/28



9-10-27



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Item ID: D206-642-251

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Stop



Item Name: Replacement Skidtube

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Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

200

0.00



Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1-remove alodine from around hole and prepare for welding

2-Prep per QSI 005 and Insert D2649 crossbolt spacers. Weld as per QSI 004 and Dwg D3804. Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod.

Pick:

Qty ☐ Part Number ☐ Description ☐ Batch

A/R ☐ Aluminum Rod ☐

*M 112507 86 09/10/28*

3-Grind welds flush as per Dwg D3804.

*DD 9-10-29*

4-Using DT8733, insert (2) D3286-3 spacers as per QSI 004 and Dwg D3804. Remember to back drill each hole to Ø0.402" before welding other side. Use SS rod as required.

A/R ☐ SS Rod ☐

*SE 09/10/28*

5-Counterbore 5/16" x 0.750" deep except 7th hole from Aft end as per Dwg D3804. Deburr

*DD 9-10-29*

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Item Name: Replacement Skidtube

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Cust Item ID:

Required Date: 27/10/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210	HandFinishing	0.00							
	HandFinish	0.00							
Hand Finishing	Memo Install D2680-041 Nut Plate as per Dwg D3804								
220	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
	QC	0.00							
Quality Control	Memo								
230	QC5- Inspect part completeness to step on W/O	0.00							
	QC	0.00							
Quality Control	Memo								

DP 9-10-29

QC102 Sorkul29

QC9 PD 09.10.29

2 Sorkul29

(XO) /



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Setup Start



Revision ID: M

Stop



Item Name: Replacement Skidtube

Start Date: 15/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 27/10/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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240

Pressure Wash per QSI005 4.3

0.00



HandFinish

Memo

0.00

Hand Finishing

MD 09/11/02

X1

250

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME: 3:20  
OVEN TEMPERATURE: 320°  
FINISH TIME: 3:50

209-11-2

①

260

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

MD 09/11/05

X1

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Setup Start



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Item Name: Replacement Skidtube

Start Date: 15/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 27/10/2009 Req'd Qty: 1.00

Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

270

0.00



HandFinishing

HandFinish

Memo

0.00

Hand Finishing

1-Install D2651-3 O-Rings on D2651-1 plugs with Petroleum Jelly and install plugs as per Dwg D3804. Clean excess adhesive.

BR 09-11-5 D.

280

0.00



HandFinishing

HandFinish

Memo

0.00

Hand Finishing

1-Install D2646 Aft Cap and seal with Sikaflex. Clean excess adhesive  
A/R ☐ Sikaflex-291 ☐ *M11234*  
Sikaflex expire date: ☐ *10/20*

2-Wing Walk as per Dwg D3804 and QSI 005 4.4 ☐  
Batch: *M112100*

BR 09-11-5 D.

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Item ID: D206-642-251

Accept



Setup Start



Revision ID: M

Stop



Item Name: Replacement Skidtube

Start Date: 15/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 27/10/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

290 QC3- Inspect Part Finish

0.00



M 09/11/05

QC

Memo

0.00

(X1)

Ø

Quality Control

300 QC5- Inspect part completeness to step on W/O

0.00



2) S 07/11/05

QC

Memo

0.00

(H/LH)

Ø

Quality Control

310 Packaging 0.00



Packaging

Packaging

Memo

0.00

Identify and pack for shipping as per PPP D206-642-251

Location:

PPP Rev:

PAP

52821

10/11/05

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Item ID: D206-642-251

Accept



Setup Start



Revision ID: M

Stop



Item Name: Replacement Skid tube

Start Date: 15/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 27/10/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

320

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/11/06 *[Signature]*mf  
09-11-05

# Picklist Print

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Page 1

Work Order ID: 52857

Parent Item: D206-642-251RevA

Parent Item Name: Replacement Skidtube

Comments:

Start Date: 15/10/2009

Required Date: 27/10/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2620RevB		Manufactured	No			110	Each	19.0000	1.0000			
Skidtube, 206 Skidtube												

*Handwritten:* 9-10-19

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	19	
45898	19	

D3286-1RevA

Manufactured No



Doubler

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	27	
44286	1	
46440	6	
47692	20	

D2647RevF

Manufactured No



Cap

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	27	
10773	7	
43846	20	

*Handwritten:* 9/10/26

*Handwritten:* BE 09/10/20

# Picklist Print

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Work Order ID: 52857



Parent Item: D206-642-251RevA



Parent Item Name: Replacement Skidtube

Start Date: 15/10/2009

Required Date: 27/10/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
CR3212-4-04  Cherry Rivet		Purchased	No			180	Each	704.0000	52.0000			

*Handwritten signature*  
9-10-27

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	704	
109297	26	
109740	16	
110153	6	
111127	78	
112314	378	
112612	200	

*Handwritten circled number 61*

D2654-3RevE1

Manufactured No

180

Each

10.0000

1.0000



Web

*Handwritten signature*  
9-10-27

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	10	
48679	10	

*Handwritten circled number 12*

# Picklist Print

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Work Order ID: 52857

Parent Item: D206-642-251RevA

Parent Item Name: Replacement Skidtube



Start Date: 15/10/2009

Required Date: 27/10/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2649RevB1		Manufactured	No			200	Each	617.0000	20.0000			
												
Cross Bolt Spacer												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
LG	83	
51529	83	
Main Warehouse		
ST	534	
36013	5	
47112	383	
48271	146	

20 BE 09/10/28

D3286-3RevA

Manufactured No

200

Each

43.0000

2.0000



Spacer

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	43	
35048	1	
41900	1	
43862	1	
46643	40	

2 BE 09/10/28

# Picklist Print

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Work Order ID: 52857

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Parent Item Name: Replacement Skidtube

Start Date: 15/10/2009

Required Date: 27/10/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
CCR264SS3-3		Purchased	No			210	Each	267.0000	2.0000			



Cherry Rivet

*Handwritten:* 9-10-29

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	267	
111548	52	
111827	115	
112314	100	

*Handwritten:* 2

CR3212-4-03

Purchased

No

210

Each

310.0000

2.0000



Cherry Rivet

*Handwritten:* 9-10-29

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	310	
111359	96	
112314	200	
15984	14	

*Handwritten:* 1110139

*Handwritten:* 2



# Picklist Print

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Work Order ID: 52857

Parent Item: D206-642-251RevA

Parent Item Name: Replacement Skidtube

Start Date: 15/10/2009

Required Date: 27/10/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item: Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2680-041RevB1		Manufactured	No			210	Each	79.0000	1.0000			
Nut Plate												

*Handwritten:* 9-10-29

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	79	
33061	14	
44086	65	

*Handwritten:* \*

D3805-043RevA		Manufactured	No			270	Each	0.0000	1.0000			
Wearplate Assembly Fwd, High Gear												

*Handwritten:* 52843

*Handwritten:* ①

*Handwritten:* BL. 09-11-5

D3805-047RevA		Manufactured	No			270	Each	0.0000	1.0000			
Wearplate Assembly Aft, High Gear												

*Handwritten:* 52842

*Handwritten:* ① BL 09-11-5

AN3-37A		Purchased	No			270	Each	773.0000	7.0000			
Bolt												

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	773	
105425 ✓	273	
111668	500	

*Handwritten:* 7 BL 09-11-5

# Picklist Print

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Work Order ID: 52857

Parent Item: D206-642-251RevA

Parent Item Name: Replacement Skidtube


Start Date: 15/10/2009

Required Date: 27/10/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960C10L  washer		Purchased	No			270	Each	4,446.000	7.0000			

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
OFFSHORE		
FG 112612	100	
103585	100	
Main Warehouse		
ST	4346	
112116	993	
112612	3353	

7 BL 09-11-5

MS21042L3

Purchased

No

270

Each

3,503.000 7.0000



Nut

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	3503	
110844	32	
111274	41	
111668 ✓	930	
112314	2000	
112385	500	

7 BL 09-11-5.

October 15, 2009 2:47:09 PM

Shop Packet Print

Page 6

# Picklist Print

October 15, 2009 2:47:09 PM

Work Order ID: 52857

Parent Item: D206-642-251RevA

Parent Item Name: Replacement Skidtube

Start Date: 15/10/2009

Required Date: 27/10/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3873-1RevA		Manufactured	No			270	Each	73.0000	14.0000			

Bushing

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST ~~453443~~ 28

46757 6

48267 22

Main Warehouse

ST139 45

50479 ✓ 45

11 BR 09-11-5

AN960JD10L

Purchased

No

270

Each

5,969.000 2.0000



Washer

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 5969

101291 16

104885 153

105793 236

109632 ✓ 564

110985 5000

2 BR 09-11-5.

# Picklist Print

October 15, 2009 2:47:09 PM

Work Order ID: 52857



Parent Item: D206-642-251RevA



Parent Item Name: Replacement Skidtube

Start Date: 15/10/2009

Required Date: 27/10/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

MS27039-1-08 Purchased No

270

Each

3,035.000

2.0000



Screw

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

3035

110467 ✓

192

110552

843

110835

2000

2 BL 00-11-5.

D2651-1RevB

Manufactured No

270

Each

403.0000

8.0000



Plug

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

403

43990

125

45490

28

51530 ✓

250

8 BL 00-11-5.

# Picklist Print

October 15, 2009 2:47:09 PM

Page 9

Work Order ID: 52857

Parent Item: D206-642-251RevA

Parent Item Name: Replacement Skidtube

Comments:

Start Date: 15/10/2009

Required Date: 27/10/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2651-3RevB		Manufactured	No			270	Each	1,035.000	8.0000			

O-Ring

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	1035	
43849 ✓	3	
46114 ✓	1032	

MS27039-4-06

Purchased

No

270

Each

77.0000

1.0000



Screw

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	77	
109061 ✓	77	

8 BK 09-11-5.

1 BK 09-11-5.

# Picklist Print

October 15, 2009 2:47:09 PM

Work Order ID: 52857



Parent Item: D206-642-251RevA



Parent Item Name: Replacement Skidtube

Start Date: 15/10/2009

Required Date: 27/10/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960JD416		Purchased	No			270	Each	5,441.000	1.0000			

Washer

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	5441	
102929	2	
105906	4	
106277	2	
107321	23	
107939	114	
108161 ✓	521	
108827	31	
109249	69	
110523	340	
111279	101	
111916	482	
112314	3752	
16941	0	

*BR 02-11-5.*

# Picklist Print

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October 15, 2009 2:47:09 PM

Work Order ID: 52857



Parent Item: D206-642-251RevA



Parent Item Name: Replacement Skidtube

Start Date: 15/10/2009

Required Date: 27/10/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2646RevC		Manufactured	No			280	Each	53.0000	1.0000			



Aft Cap

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

ST

53

20208

0

43801

1

46327

4

48109 ✓

48

1 BL 09-11-5.

ITEM	Qty -041	Qty -043	Part Number	Description
1	X		D3804-041	SKIDTUBE ASSEMBLY, 206 A/B LOW
2		X	D3804-043	SKIDTUBE ASSEMBLY, 206 A/B HIGH
5	1	1	D2600-1-160	EXTRUSION
6	1	1	D2640	AFT CAP
7	1	1	D2647	CAP
8	19	20	D2649	CROSS BOLT SPACER
9	6	8	D2651-1	PLUG
10	6	8	D2651-3	O-RING
11		1	D2654-3	WEB
12	1		D2654-1	WEB
13	1	1	D2680-041	NUT PLATE
14	2	2	D3286-1	DOUBLER
15	2	2	D3286-3	STUD
21	2	2	AN960JD10L	WASHER
22	1	1	AN960JD416	WASHER
23	2	2	CCR264SS3-3	RIVET
24	2	2	CR3212-4-03	RIVET
25	52	52	CR3212-4-04	RIVET
26	2	2	MS27039-1-08	SCREW
27	1	1	MS27039-4-06	SCREW

#### NOTES

- 1) MATERIAL: N/A
- 2) FINISH: -CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
-POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 7) IDENTIFICATION: NONE
- 8) WEIGHT: 12.5 lb
- 9) WELD PER DART QSI 004
- 10) BENDING: DAMAGE TOLERANCE ON FWD BEND:  
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- 11) BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015
- 12) INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE)

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*09-10-15*

**RELEASED**  
*CP 09-07-07*  
per ECN 09-530

A	NEW ISSUE	MB	08.07.07
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>91</i>		
DRAWN	<i>91</i>		
CHECKED	<i>91</i>		
MFG. APPR.	<i>91</i>		
DE APPR.	<i>91</i>		
DATE	08.07.07		

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PORT HADLOCK, WA

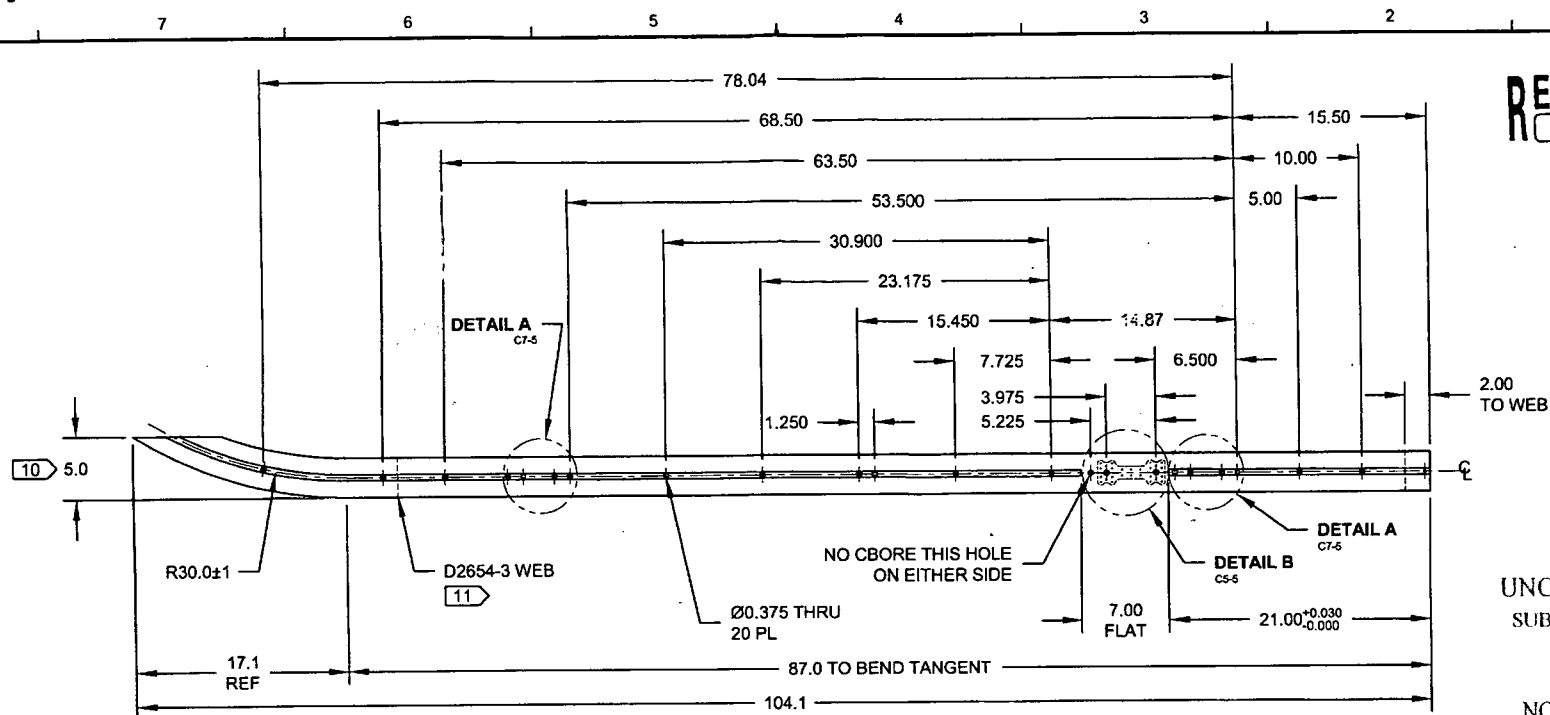
DRAWING NO. REV. A  
D3804 SHEET 1 OF 5

TITLE SCALE  
SKIDTUBE ASSEMBLY, 206A/B NTS

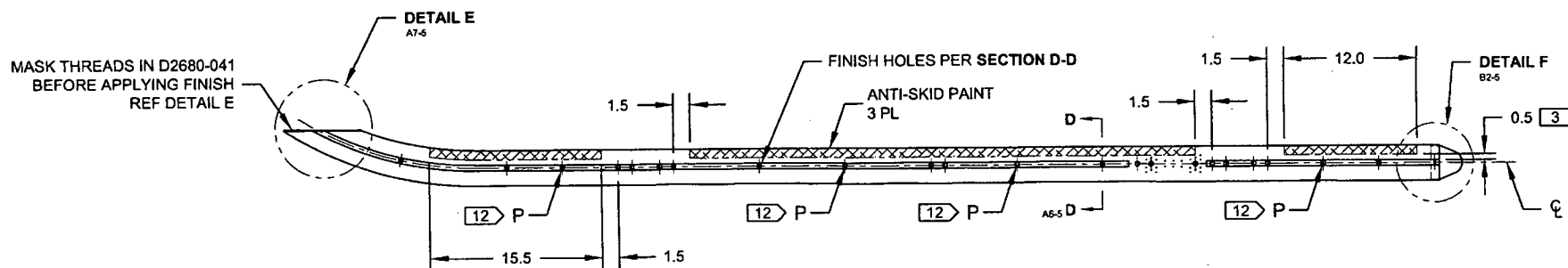
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**D3804-043 BENDING/DRILLING DETAIL**



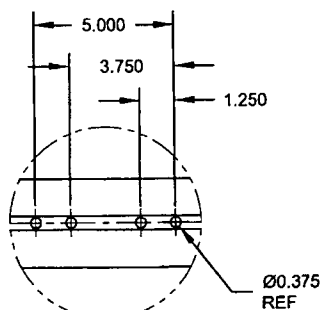
**D3804-043 ASSEMBLY/FINISHING DETAIL**

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09-03-07

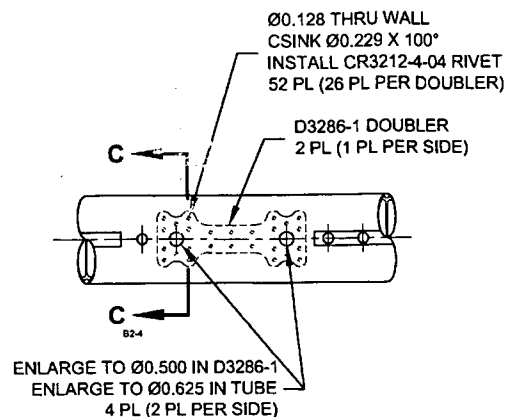
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MFG. APPR.	99	D3804	SHEET 3 OF 5
APPROVED	99	TITLE	SCALE
DE APPR.	99	SKIDTUBE ASSEMBLY, 206A/B	NTS
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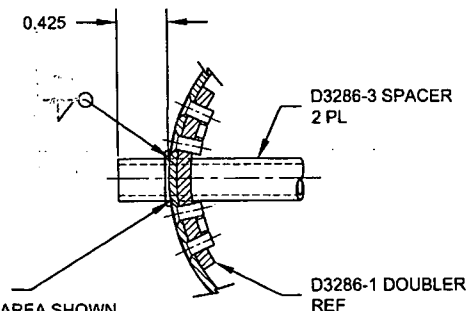
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CP 09.03.03



**DETAIL A** DB-2  
C2-2  
DB-3  
C2-3  
SCALE NONE

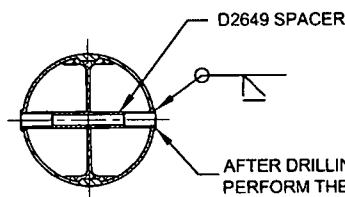


**DETAIL B** C3-2  
C3-3  
SCALE NONE



- TO INSTALL D3286-1/3:
1. GRIND OFF FLANGE IN AREA SHOWN, FLUSH WITH OUTSIDE SURFACE OF ROUND TUBE
  2. LOCATE & DRILL D3286-1 DOUBLER USING DT3286-1T1
  3. ENLARGE HOLES IN D3286-1 TO Ø0.500
  4. ENLARGE HOLES IN TUBE TO Ø0.625 AND CHAMFER HOLE 0.03 X 45°
  5. RIVET D3286-1 TO TUBE
  6. INSERT D3286-3 SPACER
  7. WELD IN PLACE AND GRIND FLUSH

**SECTION C-C** C6-4  
PARTIAL SECTION  
SCALE NONE

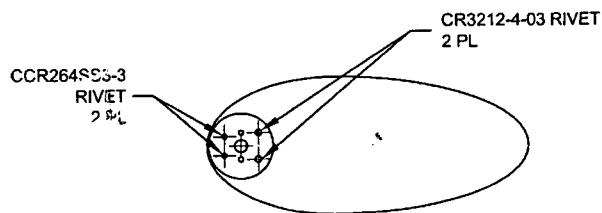


- AFTER DRILLING AND BENDING ASSEMBLY PERFORM THE FOLLOWING FOR Ø0.375 HOLES ONLY:
1. CHAMFER HOLE 0.03 X 45°
  2. INSERT D2649 SPACER
  3. WELD INTO PLACE AND GRIND FLUSH
  4. CBORER TO Ø0.313 X 0.75 DP (EXCEPT WHERE INDICATED)

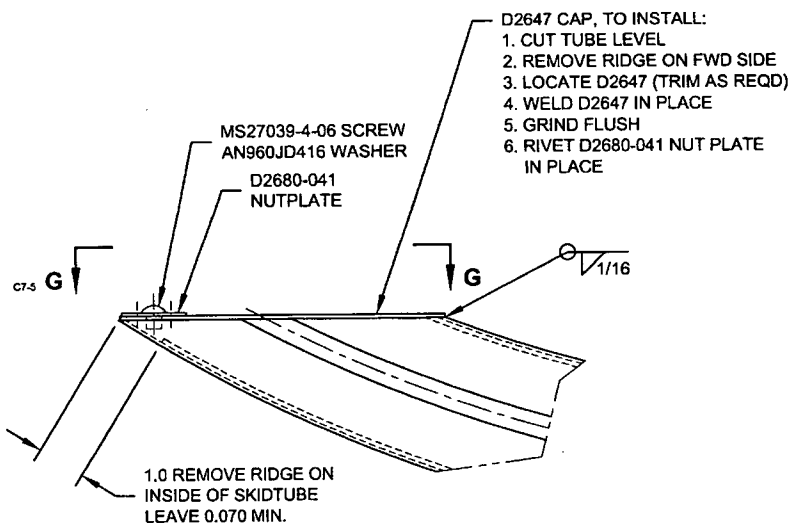
**SECTION D-D** A4-2  
A4-3  
FOR Ø0.375 HOLES ONLY  
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DE APPR.	41	SKIDTUBE ASSEMBLY, 206A/B	NTS
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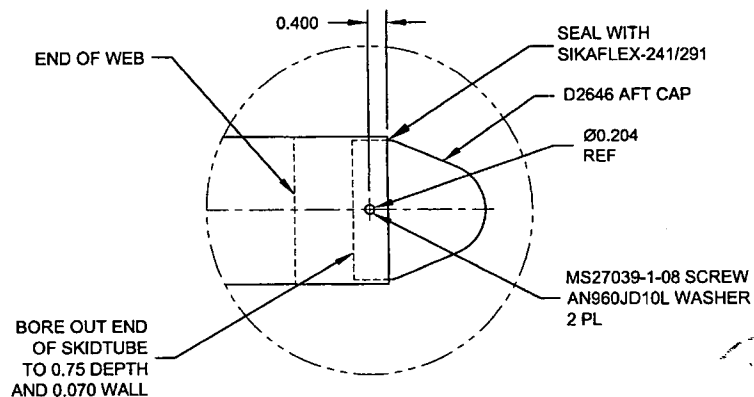
**VIEW G-G**  
SCALE NONE A7.5



**DETAIL E**  
SCALE NONE B7.2 B7.3

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**DETAIL F**  
SCALE NONE B2.2 B2.3

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CHECKED	97	DRAWING NO. D3804	REV. A
MFG. APPR.	97	SHEET 5 OF 5	
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NO. 214

AWS D17.1.2001  
QUALIFICATION TEST RECORD

Name: Barclay Elliott  
Job number: 52855  
Part number: D206-K42-251  
Description: 206 skid tube  
Welding Process: Tig[☒] Mig[ ]  
Base material: Aluminium  
Current: AC[☒] DC[ ]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[ ]  
Penetration: pass[☒] fail[ ]

UNACCEPTABLE

Cracks: pass[☒] fail[ ]  
Undercut: pass[☒] fail[ ]  
Pin holes: pass[☒] fail[ ]  
Overlap (cold lap): pass[☒] fail[ ]  
Porosity (surface): pass[☒] fail[ ]  
Coloration: pass[☒] fail[ ]

Qualifier Pat Dineen Date of Test Coupon 09.10.29

Welder Barclay Elliott Date of Test Coupon 09.10.29

The above named individual is qualified in accordance with AWS D17.1.2001 to weld